



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5331-041
Job Sheet 180054



Part No: D5331-041

Job Qty: 1 ea

Part Name: Basket Base Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/28/18

Job Tracking No:

Due Date: 7/13/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B SHEETS 1,2,4,5,6,7,8 IPP REV:A 15.10.15 NEW ISSUE DD VERF:JLM IPP REV:B 17.03.27
add D4016-7 DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/13/18	7/13/18	0.00	0.00	Start Up Large Fab-6		
100	Large Fab	1 pcs	7/13/18	7/13/18	0.00	15.77	Large Fab 1		
110	QC	1 pcs	7/13/18	7/13/18	0.00	0.00	QC9		
120	QC	1 pcs	7/13/18	7/13/18	0.00	0.00	QC5		
125	HandFinish	1 pcs	7/13/18	7/13/18	0.00	2.34	HandFinish2		
130	Powdercoat	1 pcs	7/13/18	7/13/18	0.00	0.53	Powdercoat2		
140	QC	1 pcs	7/13/18	7/13/18	0.00	0.00	QC3		
170	Packaging	1 pcs	7/13/18	7/13/18	0.00	0.00	Packaging3-2		
180	QC21-SA	1 Ea	7/13/18	7/13/18	0.00	0.00	QC21		

Part Op 100 - 1- Assemble ribs and weld as per dwg D5331 using DT10197 ***inspect before welding mesh*** (54.63

Descriptions: CRITICAL DIMENSION)*** 2- Weld gusset and handle plate as per dwg 3- Cut mesh as per dwg D5328-1 4- Tack weld mesh on basket as per dwg D5331 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 5- Weld hinge (6) and Mounting brackets (2) as per dwg D5331 ***Take lid to locate hinge and bracket*** ***On one of the hinge weld stopper D4016-7 as per dwg*** 6- Weld D5325-5 foot as per dwg (CRITICAL)

130 - 1- Plug holes and mask only interior of hinge (6) prior to powder coat 1ST COAT: START TIME: 2:00p -
OVEN TEMPERATURE: 375°F FINISH TIME: 2:30p *****2nd coat if necessary***** 2ND
COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5068733
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	5068414
D3916-5	Light Rib	2 Ea (2 ea)	90-Start up Operation	5084063
D4016-1	Hinge Half, Base	6 Ea (6 ea)	90-Start up Operation	5083794
D4016-7	Stop	1 Ea (1 ea)	90-Start up Operation	5083477
D4021-1	Handle Plate	1 Ea (1 ea)	90-Start up Operation	5158827
D5325-041	Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5068416
D5325-3	Light Rib	1 Ea (1 ea)	90-Start up Operation	5064471
D5325-5	Foot	4 Ea (4 ea)	90-Start up Operation	5066084
D5326-041	Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5067402
D5326-043	Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5065450
D5327-1	Rib	1 Ea (1 ea)	90-Start up Operation	5161094
D5327-11	Rib	4 Ea (4 ea)	90-Start up Operation	5137877
D5327-13	Rib	1 Ea (1 ea)	90-Start up Operation	5065506
				5067675

D5327-15	Cap	1 Ea (1 ea)	90-Start up Operation
D5327-3	Rib	1 Ea (1 ea)	90-Start up Operation
D5327-5	Rib	1 Ea (1 ea)	90-Start up Operation
D5327-7	Rib	1 Ea (1 ea)	90-Start up Operation
D5327-9	Rib	2 Ea (2 ea)	90-Start up Operation
D5328-3	Mesh Base, Aft	1 Ea (1 ea)	90-Start up Operation
D5328-5	Mesh Base, Fwd	1 Ea (1 ea)	90-Start up Operation
D5329-1	Gusset	2 Ea (2 ea)	90-Start up Operation
D5330-1	Handle Plate	2 Ea (2 ea)	90-Start up Operation
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	90-Start up Operation

8161209
 5065574
 5065380
 50423472065631
 5065631
 5008229
 5094848
 5162049
 5054668
 5070544

M.V. 004214

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	53	0
	D3913-15	1	6	0
	D3916-5	2	7	0
	D4016-1	6	40	0
	D4016-7	1	2	0
	D4021-1	1	34	0
	D5325-041	1	2	0
	D5325-3	1	3	0
	D5325-5	4	4	0
	D5326-041	1	3	0
	D5326-043	1	0	0
	D5327-1	1	4	0
	D5327-11	4	4	0
	D5327-13	1	11	0
	D5327-15	1	5	0
	D5327-3	1	3	0
	D5327-5	1	3	0
	D5327-7	1	1	0
	D5327-9	2	6	0
	D5328-3	1	2	0
	D5328-5	1	0	0
	D5329-1	2	2	0
	D5330-1	2	10	0
	M304EX0.75-16F	32	903	0

Part Specifications

Specifications could not be found.